

Date: Tuesday, 15/07/2008 4:12:29 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MID TUBE ASSEMBLY
Job Number :	40522		
Estimate Number :	10469		
P.O. Number :		Part Number :	D3391023
This Issue :	15/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3391 REV G
First Issue :	1/1	Project Number :	N/A
Previous Run :	40521	Drawing Revision :	G
Written By :		Material :	
Checked & Approved By :	<u>TUD 08-7-16</u>	Due Date :	08/08/2008
Comment :	Est. A 05.10.20 New Issue KJ/EC Est. B 06.02.10 ECN773 dwg rev.D EC est C 07.03.20 rev F dwg EC est D 07.03.28 re-format EC est E 07.10.31 ecn 1053P EC Est Rev:F ECN 1056 07-11-13 DD verified by: EC		
Qty:	1	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description
1	D2500-1-100	Extrusion

Batch

37065 SL8-7-17

2.0	D3391021	Fwd Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

Batch: 336191 BE 08-7-22

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

SL8-7-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MID TUBE ASSEMBLY

Job Number: 40522

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

11-Open .375" holes to .438" ***do not open fwd saddle holes***

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drill remaining 6 wearplate holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- Open 12 wearplate holes in D3391-021 to 0.297" dia.

18-Deburr and blow out all chips from inside tube

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H 8-8-13

8-8-17



8-8-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-023 PAR #: N/A Fault Category: Prod / Skidibe NCR: Yes No DQA: D Date: 28/08/09
D412-742-043 QA: N/C Closed: D Date: 28/08/09

NCR: <u>48522</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/08/09</u>	<u>3</u>	Employee placed drill jig in the incorrect location, drilling the holes too far back. See W/O D3391-021 B36191.	<u>[Signature]</u> <u>08/08/09</u>	Scrap part & replace. <u>B37065</u>	<u>[Signature]</u> <u>08/08/09</u>	<u>S</u> <u>08/08/09</u>	<u>[Signature]</u> <u>08/08/09</u>	<u>S</u> <u>08/08/09</u>
		R.C.: Employee error, inadequate training - not too familiar with part.						

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:29 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 40522

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE 8-8-13

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

B31897

A/R

Sikaflex-241/-291

M107888

Sikaflex expire date:

8-11-30

Start: 8-8-13 Time: 200

Finish: 8-8-1 Time: 6

DP 8-8-13

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open float bag holes as per dwg

2-C'sink float bag holes as per dwg

3- Prepare tube for welding

4-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

DP 8-8-13

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10000-140

10.0

D36811

Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

SPACER

batch: 35738

ET 08-08-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action, Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:29 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 40522

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



touch up holes only



08-08-18

Comment: LANDING GEAR RESOURCE 1

Weld crossbolt spacer as per dwg D3391 & QSI 004

RE 08/08/15

12.0

Socio



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

S

08/08/19

(X)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/08/19

(X)

14.0

POWDER COATING

POWDER COATING



M108523



(X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:40

OVEN TEMPERATURE:

320 °F

FINISH TIME:

2:10

M.A 08/08/19

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



W



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-19 (X)

16.0

ALS41032130

Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

INSERT

batch: *M1105819*

or equivalent

per QSI 017

W

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ Install inserts as per dwg D3391

✓ touch-up holes in D3391-021 with alodine

W 08-08-20 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: MID TUBE ASSEMBLY

Job Number: 40522

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC5

INSPECT WORK TO CURRENT STEP



10808-270



Comment: INSPECT WORK TO CURRENT STEP
Inspect each insert using DT8821

19.0

PACKAGING 1

PACKAGING RESOURCE #1



10808-270



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *W/O 41046 D412-742-013 (AS/W/O)*

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10808-270

Job Completion



W 08.08.29

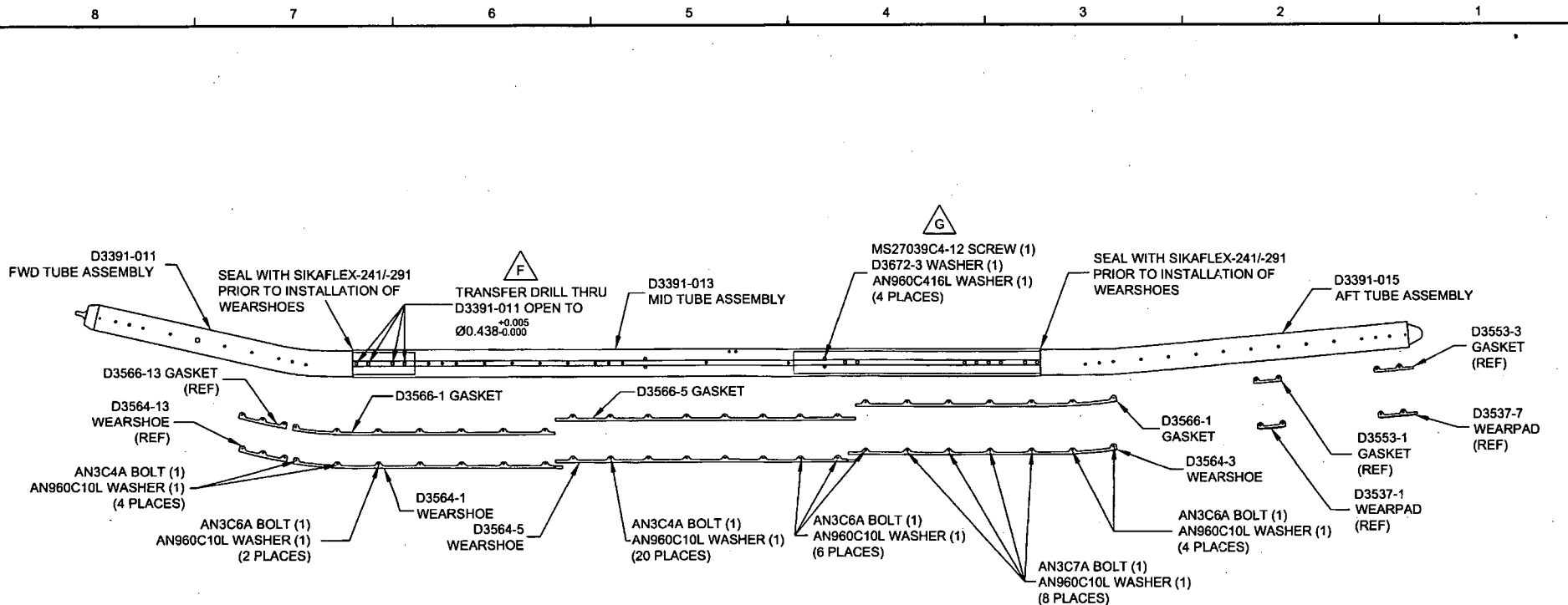
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041 ASSEMBLY

RELEASED
27-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
4	D3872-3	WASHER
24	AN3C6A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
4	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3870-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		

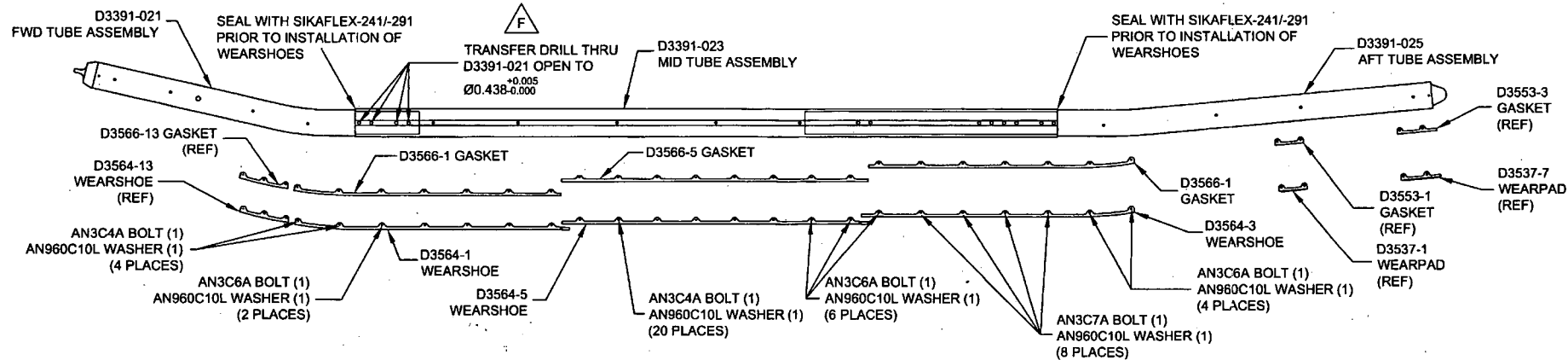
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PORT HADLOCK, WA

DRAWING NO. D3391 REV. G
SHEET 1 OF 8

TITLE 412 FLOAT SKIDTUBE SCALE NTS

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D3391-043 ASSEMBLY

RELEASED
07.11.94

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

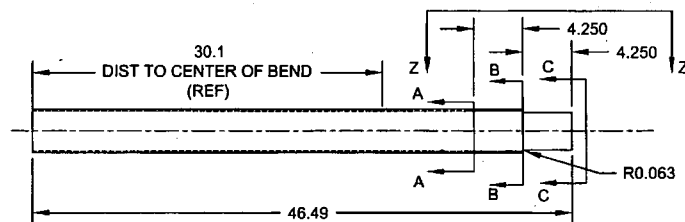
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

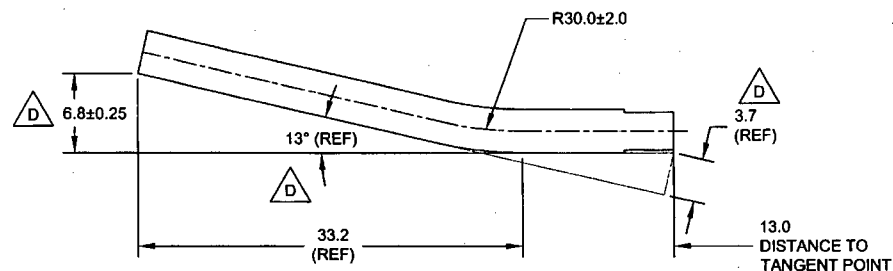
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C.BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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DRAWN	<i>SC</i>	PORT HADLOCK, WA
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MFG. APPR.	<i>h</i>	D3391 SHEET 2 OF 8
APPROVED	<i>h</i>	TITLE SCALE
DE APPR.	<i>h</i>	412 FLOAT SKIDTUBE NTS
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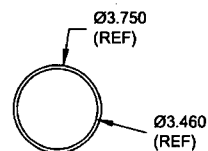
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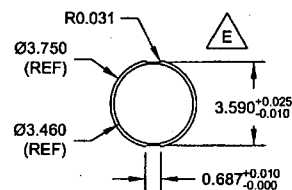
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



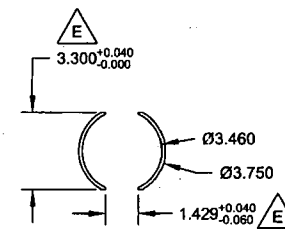
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



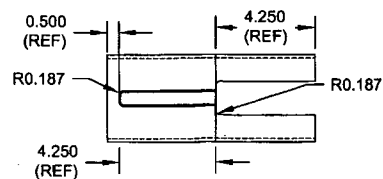
SECTION A-A
(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)

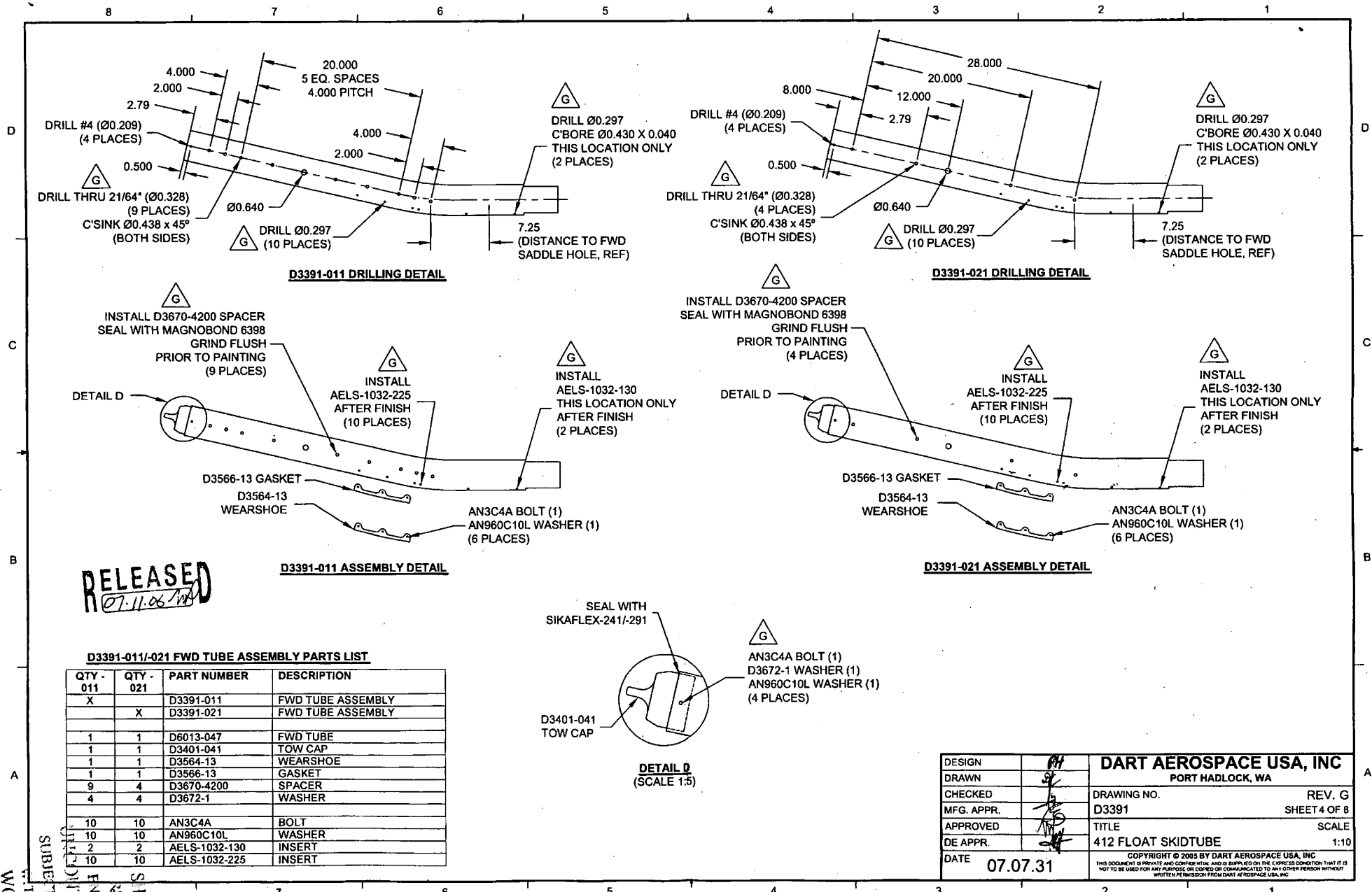


VIEW Z-Z
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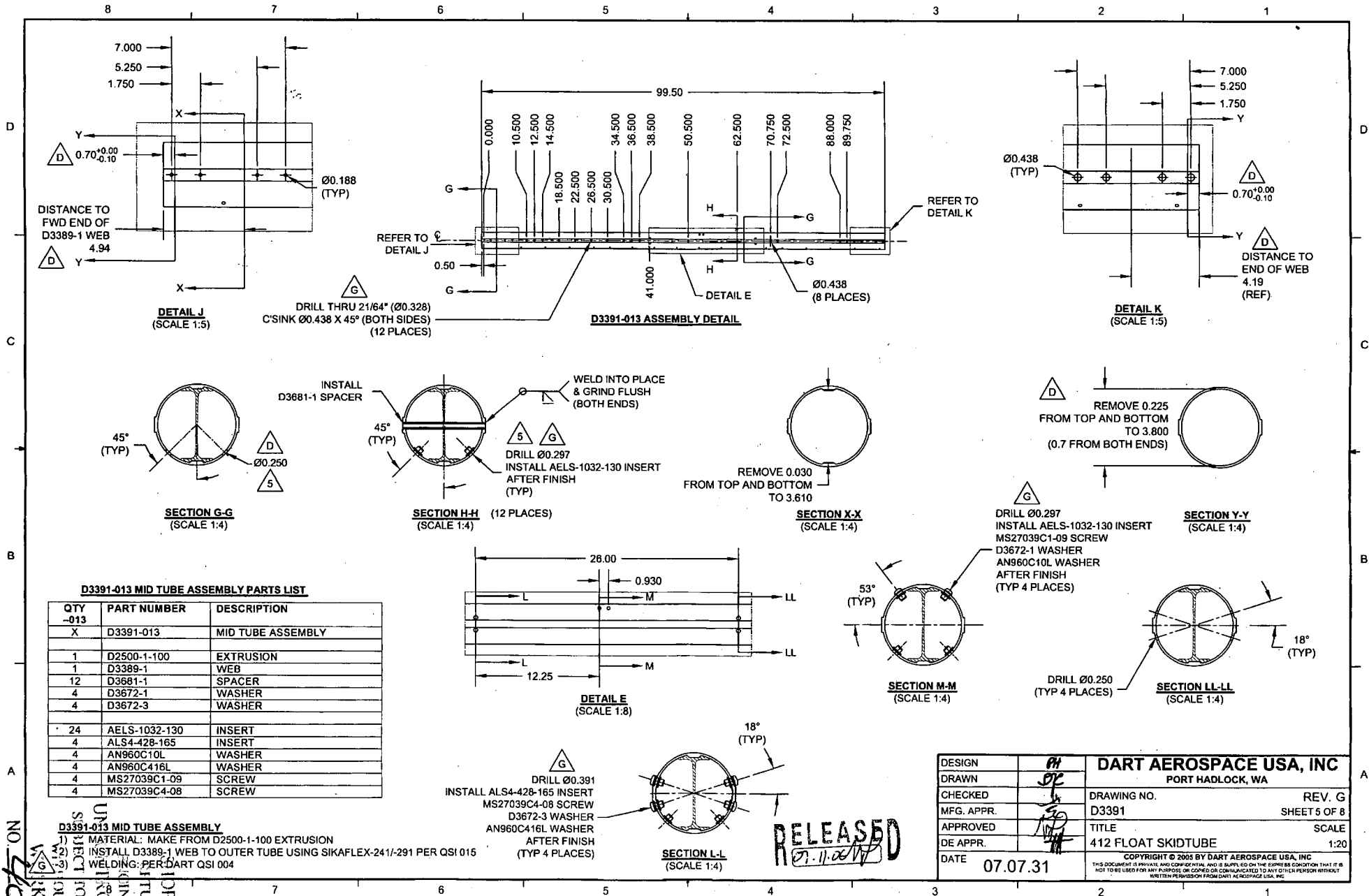
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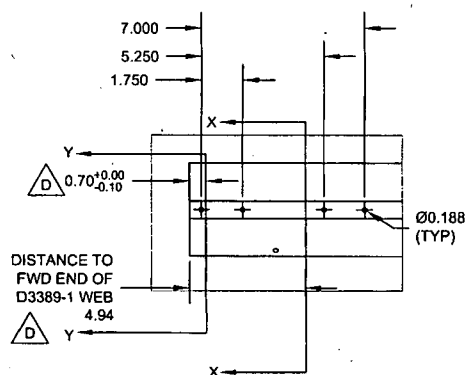
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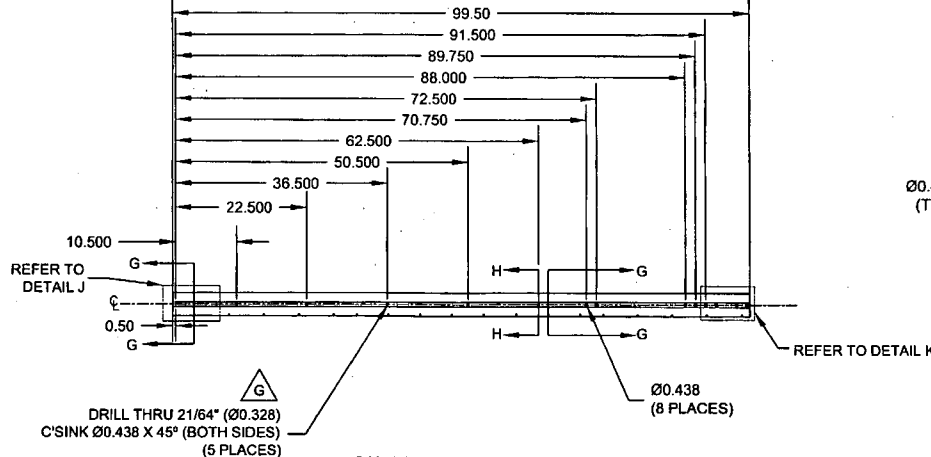
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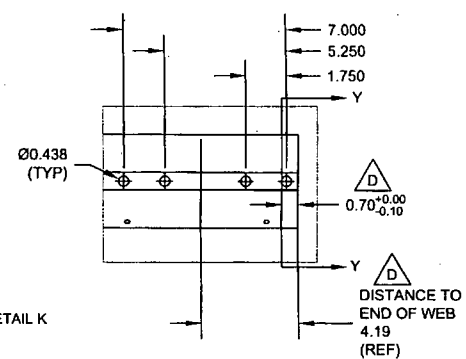
27.11.06



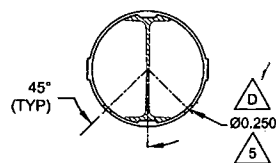
DETAIL J
(SCALE 1:5)



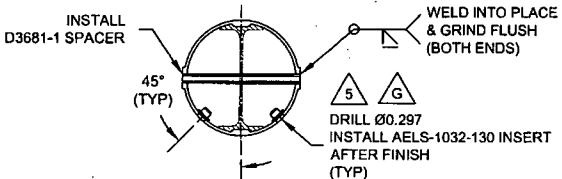
D3391-023 ASSEMBLY DETAIL



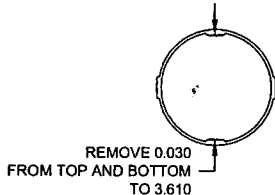
DETAIL K
(SCALE 1:5)



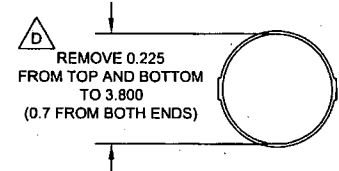
SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)



SECTION X-X
(SCALE 1:4)



SECTION Y-Y
(SCALE 1:4)

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

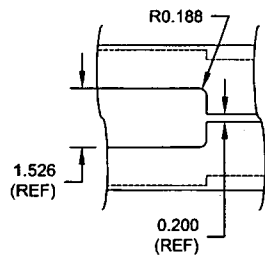
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

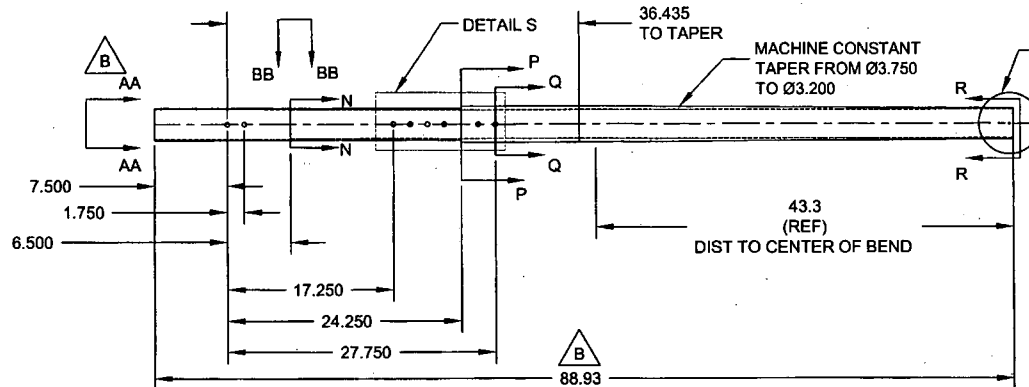
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07.11.06.11

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DE APPR.	DE	412 FLOAT SKIDTUBE	1:20
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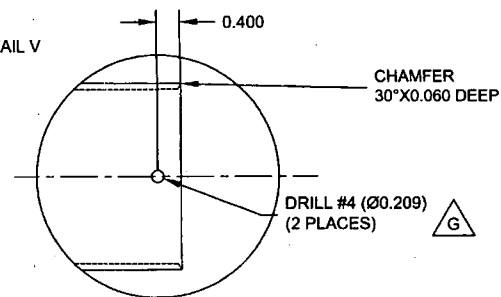
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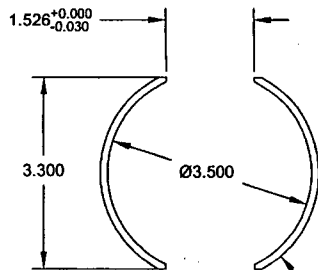
VIEW BB-BB
(SCALE 1:3)



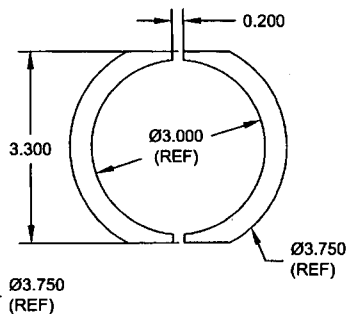
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



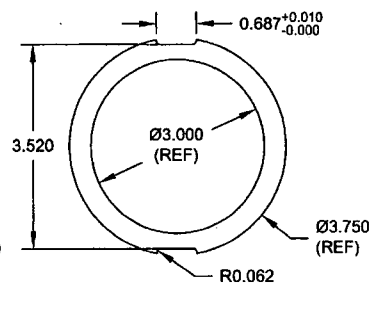
DETAIL V
(SCALE 1:2)



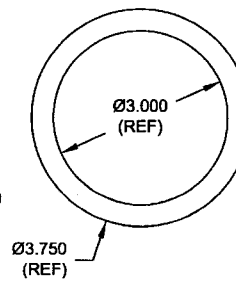
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(SCALE 1:2)



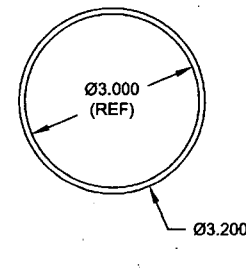
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(SCALE 1:2)



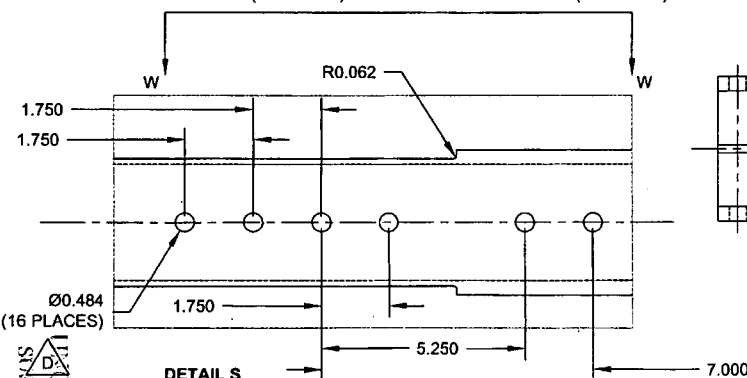
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(SCALE 1:2)



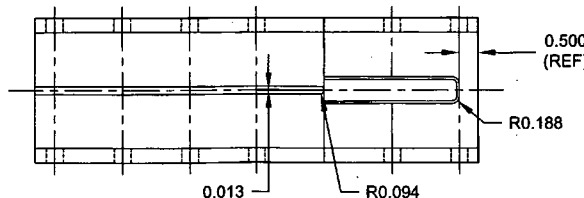
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAILS S
(SCALE 1:3)

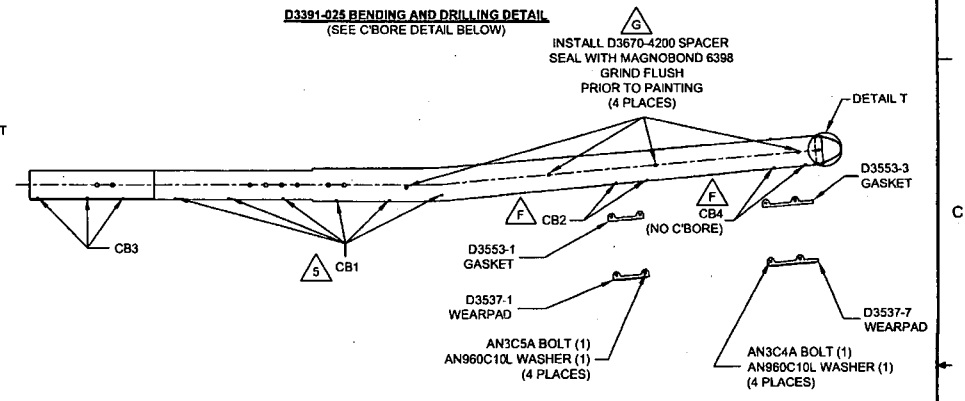
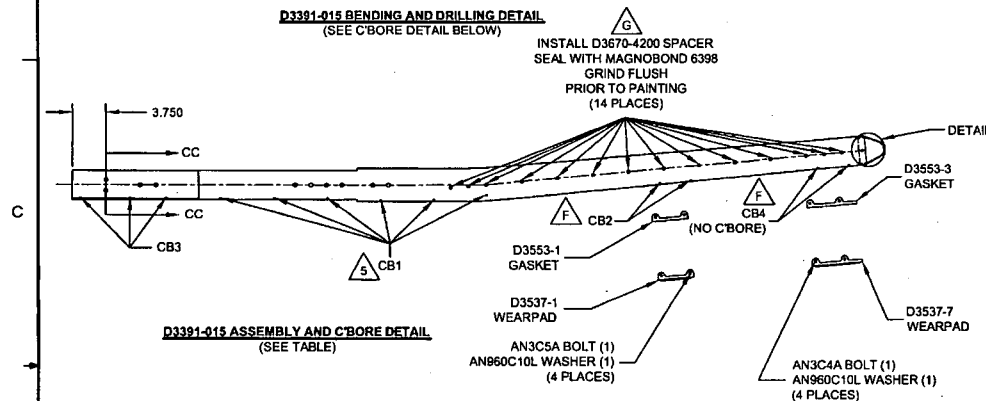
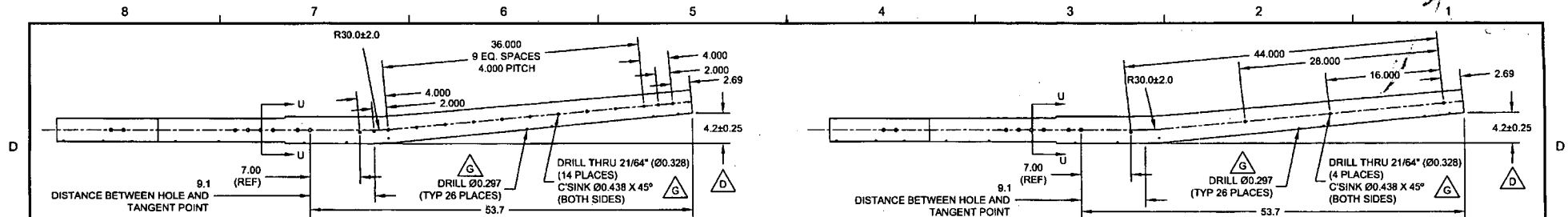


VIEW W-W
(SCALE 1:3)

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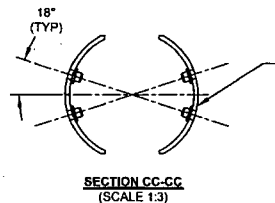
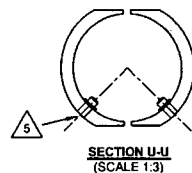
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	JLC	PORT HADLOCK, WA	
CHECKED	JLC	DRAWING NO. D3391	REV. G
MFG. APPR.	JLC	SHEET 7 OF 8	
APPROVED	JLC	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12
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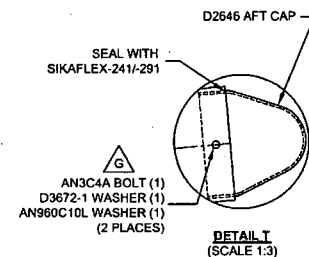


D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



DRILL Ø0.391
C'BORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)



C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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MFG. APPR.	SK	SHEET 8 OF 8	
APPROVED	SK	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12
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RELEASED
07-11-06

NO. 164

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 376130
Part number: D339103
Description: Mid tube ass.
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier P. D. J. Date of Test Coupon 08-07-29
Welder Barclay Elliot Date of Test Coupon 08-07-29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld